

Date: Wednesday, 15/08/2007 4:08:18 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FLOAT SKID ASSEMBLY |
| Job Number | : 33971A | | |
| Estimate Number | : 10756 | | |
| P.C. Number | : <i>N/A</i> | Part Number | : D412742043 |
| This Issue | : 15/08/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3391 REV F |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LANDING GEAR | Drawing Revision | : F |
| Previous Run | : 33564A | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 03/09/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : Est Rev A 05.10.13 New Issue KJ/JLM | | |
| | : Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC | | |
| | : Est Rev:C 07-05-28 As per Rev F JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

2.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B 31316

3.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B 33647

4.0

D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

*B 33243**m-l 07/08/20**(1x)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33971A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B33764

M-L

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B33802

M-L

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch:

B33458

M-L

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B33483

M-L

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch:

M105057

M-L

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Batch:

M103693

M-L

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Batch:

M103668

M-L

07/08/20

(1x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33971A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch:

M105143

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3

M104161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291

M104989

Expiry date:

08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon

M104261

A/R Sikaflex-241/-291

M104989

Expiry date:

08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser

M-L

07/08/20

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP 33971

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/22

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33971A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RD 07/08/22

Job Completion



U 07/08/22

Dart Aerospace Ltd

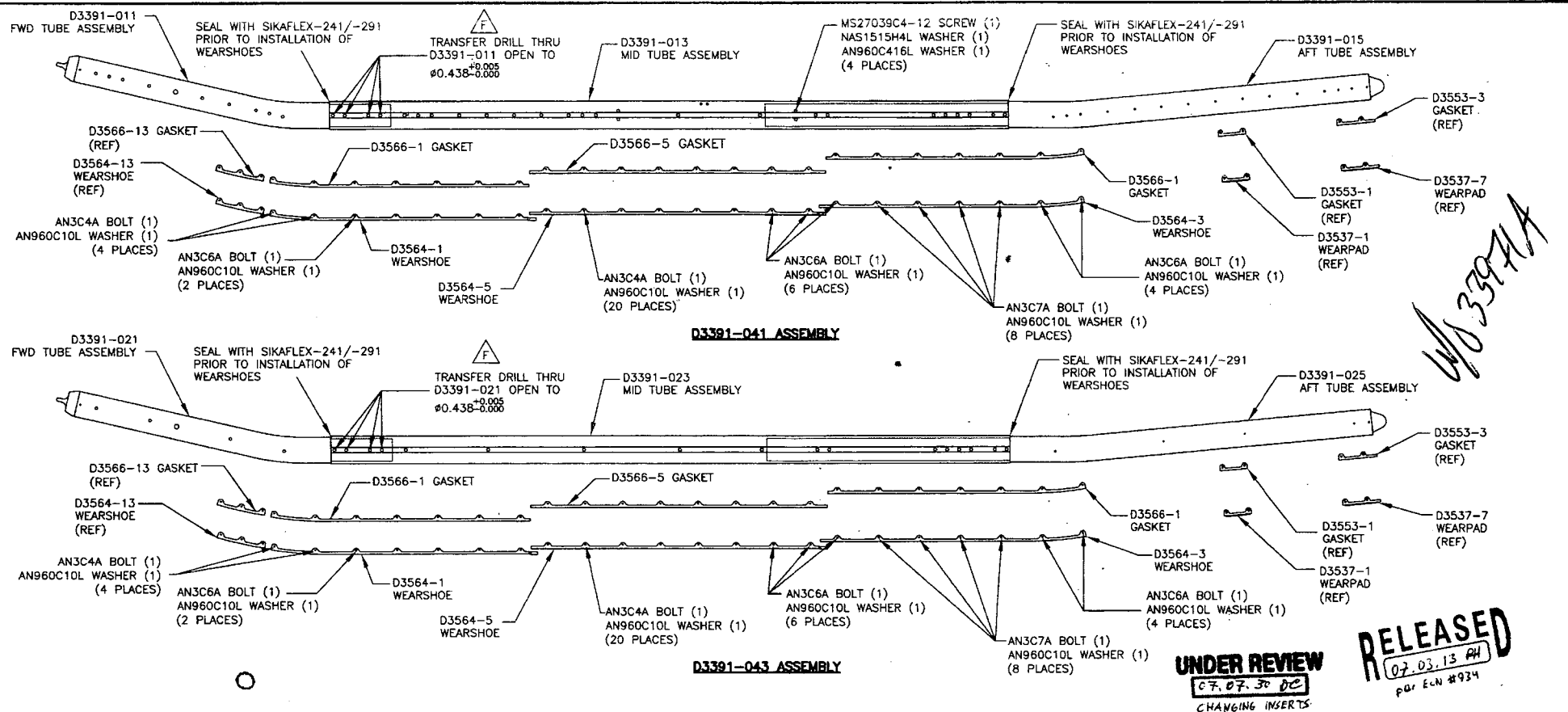
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|----------|----------|--------------|-------------------------|
| X | X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| | | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | | D3391-013 | MID TUBE ASSEMBLY |
| 1 | | D3391-015 | AFT TUBE ASSEMBLY |
| 1 | 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D3566-1 | WEARSHOE |
| 1 | 1 | D3566-3 | WEARSHOE |
| 1 | 1 | D3566-5 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 24 | 24 | AN3C4A | BOLT |
| 12 | 12 | AN3C6A | BOLT |
| 8 | 8 | AN3C7A | BOLT |
| 44 | 44 | AN960C10L | WASHER |
| 4 | 4 | MS27039C4-12 | SCREW |
| 4 | 4 | NAS1515H4L | WASHER |
| 4 | 4 | AN960C416L | WASHER |

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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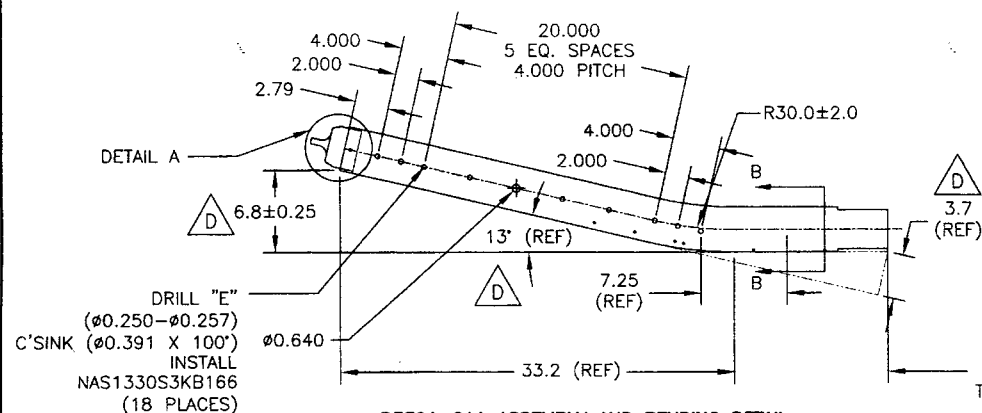
| | | |
|----------|--------------------|---|
| F | 07.01.18 | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 |
| E | 06.04.25 | CHANGE TOLERANCE, EASE MANUFACTURE |
| D | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE |
| C | 05.09.27 | LENGTHEN AFT EXTENSION |
| B | 05.06.10 | DRAWING UPDATES |
| A | 05.02.07 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D3391 |
| DATE | TITLE | SCALE |
| 07.01.18 | 412 FLOAT SKIDTUBE | NTS |

UNDER REVIEW
67.07.30 DC
CHANGING INSERTS

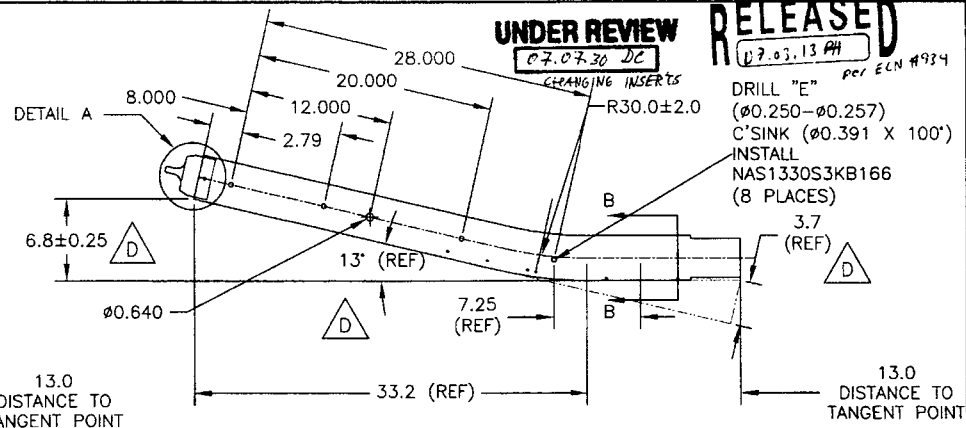
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07.03.13 RH
PAR ECU #934

UNDER REVIEW

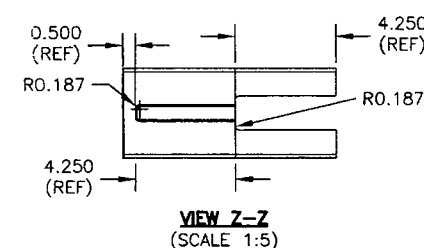
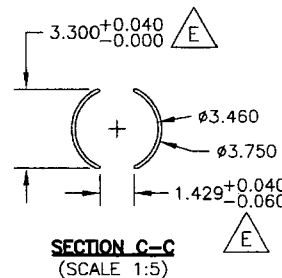
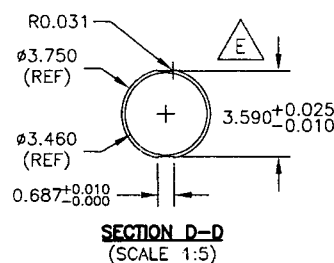
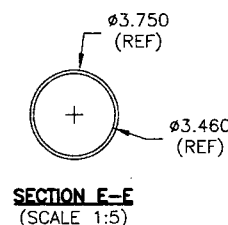
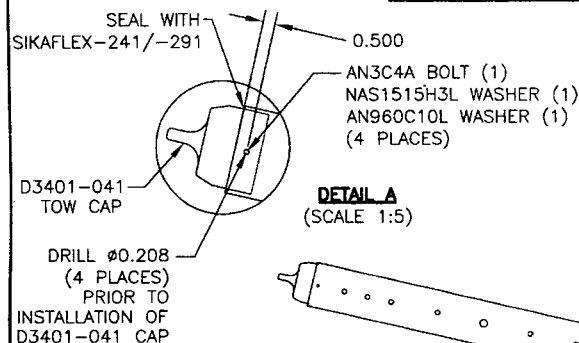
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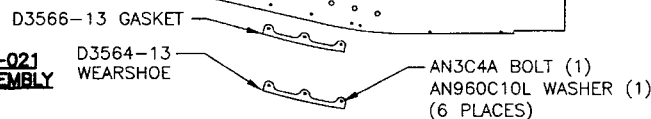
D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL

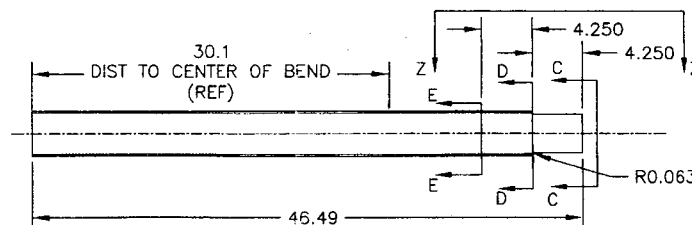
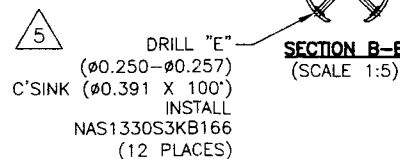


D3391-011/-021 WEARSHOE ASSEMBLY



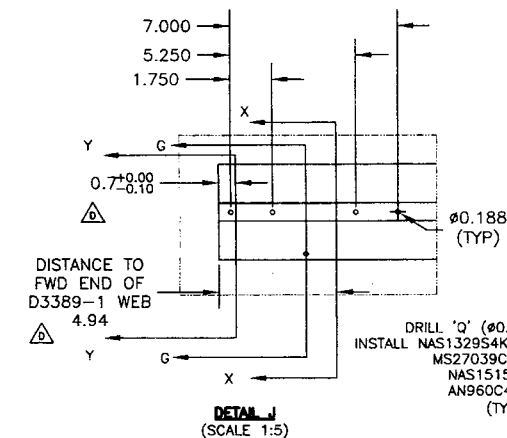
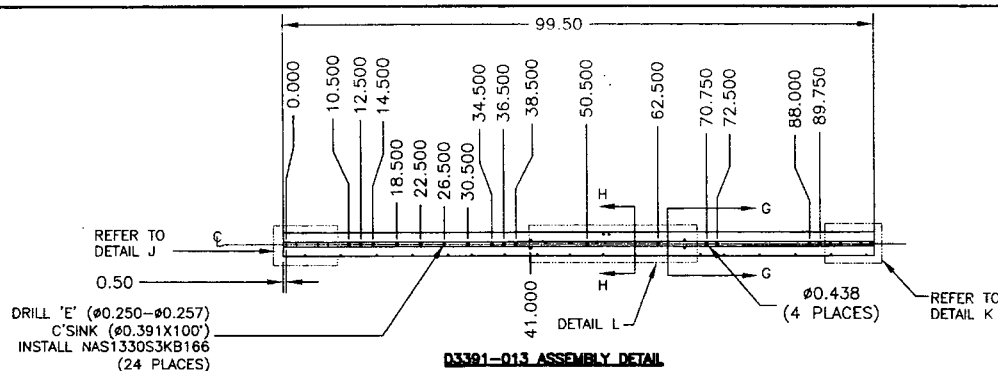
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | X | D3391-011 | FWD TUBE ASSEMBLY |
| | | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D6013-047 | FWD TUBE |
| 1 | 1 | D3401-041 | TOW CAP |
| 1 | 1 | D3564-13 | WEARSHOE |
| 1 | 1 | D3566-13 | GASKET |
| 10 | 10 | AN3C4A | BOLT |
| 4 | 4 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |
| 30 | 20 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |



D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

| | | | | | |
|--|-------------------------|-----------------------------|----------------|--|--|
| COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. | | DESIGN PH | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, MA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3391 | | REV. F SHEET 2 OF 5 | |
| DATE 07.01.18 | | TITLE 412 FLOAT SKIDTUBE | | SCALE 1:10 | |

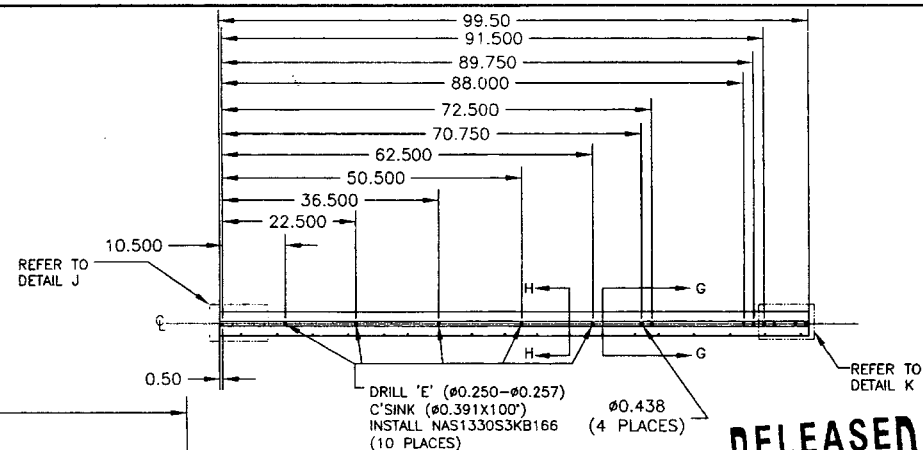


D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

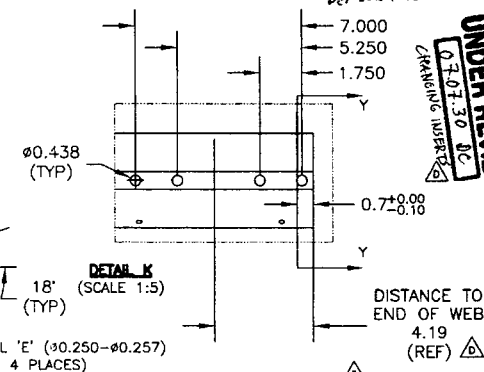
| QTY - 013 | QTY - 023 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | | D3391-013 | MID TUBE ASSEMBLY |
| | X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | 1 | D2500-1-100 | EXTRUSION |
| 1 | 1 | D3389-1 | WEB |
| 24 | 20 | NAS1330S3KB116 | INSERT (OR NAS1330C3KB116) |
| 24 | 10 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4 | | NAS1329S4KB140 | INSERT (OR NAS1329C3KB140) |
| 4 | | NAS1515H3L | WASHER |
| 4 | | AN960C10L | WASHER |
| 4 | | NAS1515H4L | WASHER |
| 4 | | AN960C416L | WASHER |
| 4 | | MS27039C1-09 | SCREW |
| 4 | | MS27039C4-08 | SCREW |

D3391-013/-023 MID TUBE ASSEMBLY

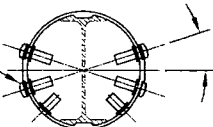
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



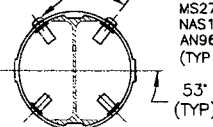
D3391-023 ASSEMBLY DETAIL



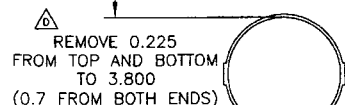
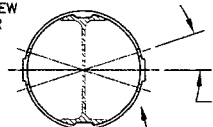
SECTION L-L (SCALE 1:4)



SECTION M-M (SCALE 1:4)

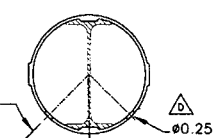


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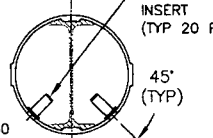


SECTION Y-Y (SCALE 1:4)

SECTION G-G (SCALE 1:4)



SECTION H-H (SCALE 1:4)



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DESIGN

PH

CHECKED

DATE

07.01.18

DRAWN BY

PH

APPROVED

TITLE

412 FLOAT SKIDTUBE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DRAWING NO.

D3391

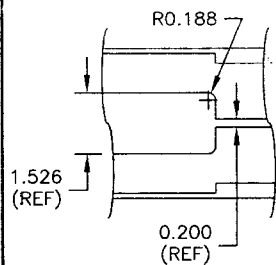
SCALE

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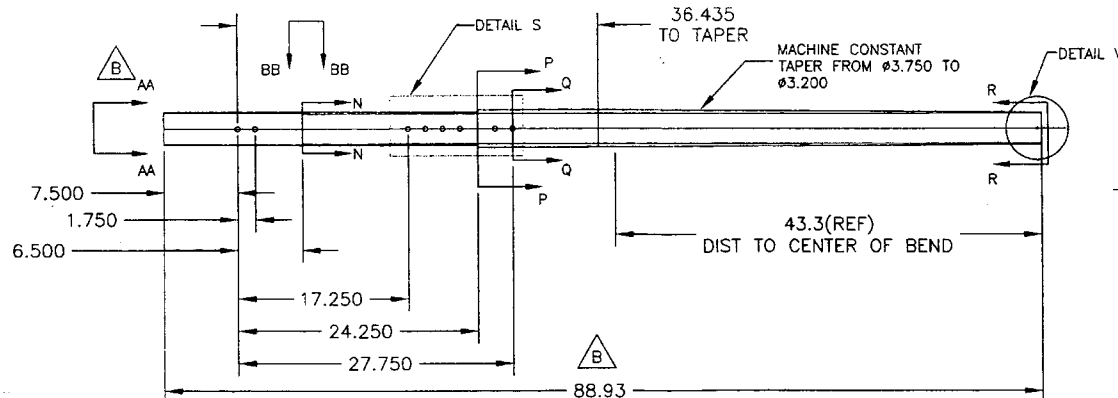
UNDER REVIEW
01.07.30 BC
07.05.13 PH
Per E.N. #934

RELEASED

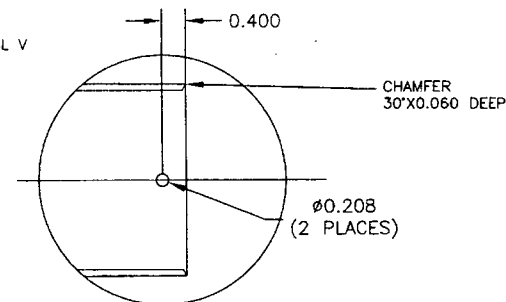
07.05.13 PH
Per E.N. #934



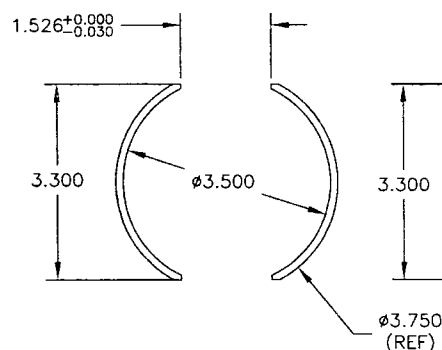
VIEW BB-BB
(SCALE 1:3)



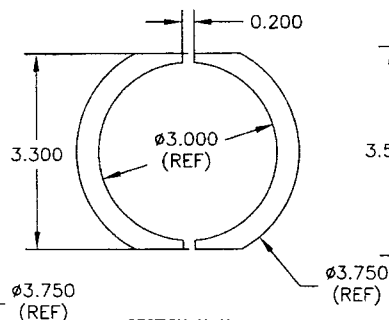
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



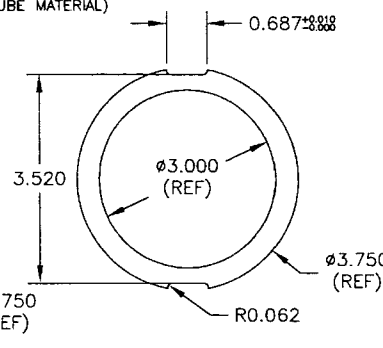
DETAIL V
(SCALE 1:2)



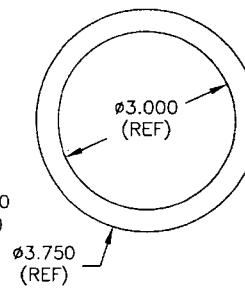
SECTION AA-AA
(SCALE 1:2)



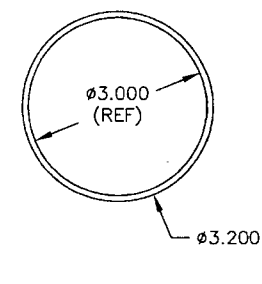
SECTION N-N
(SCALE 1:2)



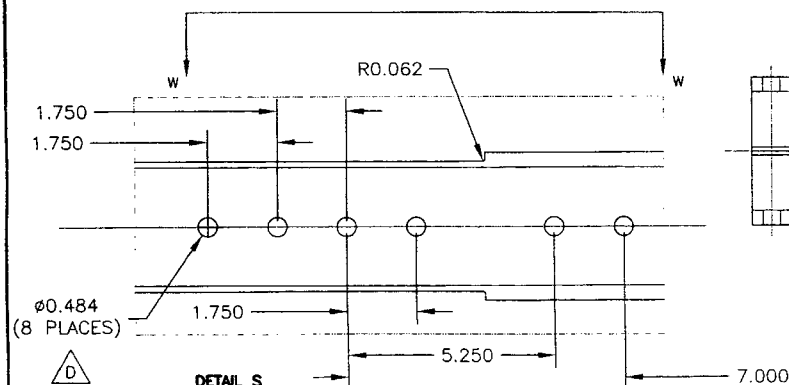
SECTION P-P
(SCALE 1:2)



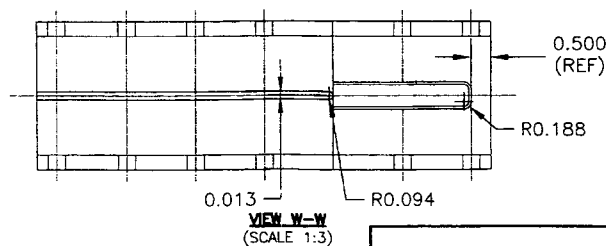
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

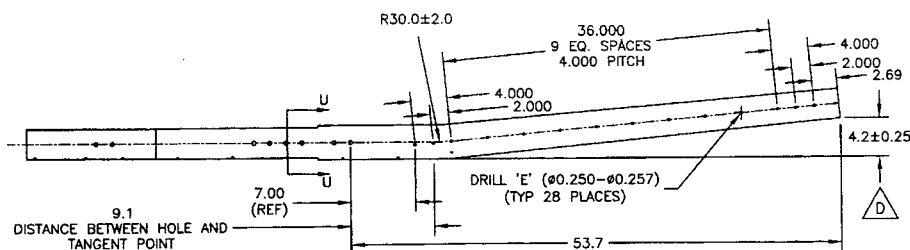
UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

RELEASED
07.05.13 PH
per ECU #934

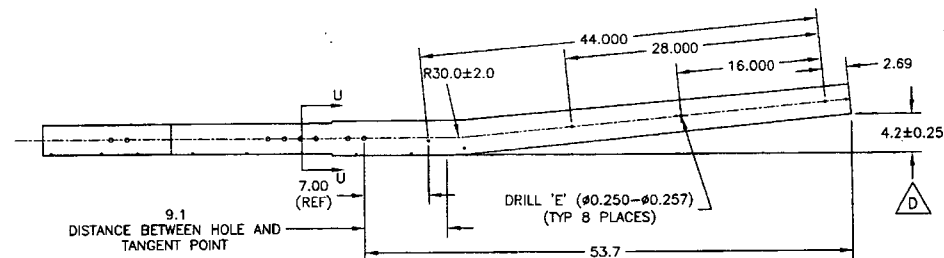
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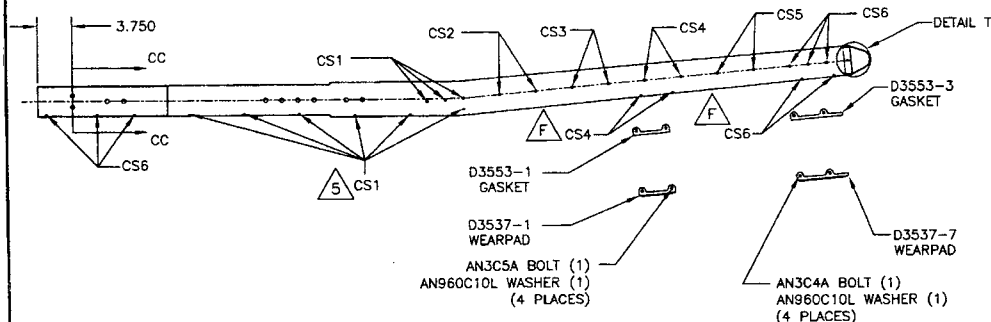
| | | | |
|------------------|-----------------------------|--|--------------|
| DESIGN PH | DRAWN BY PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA | REV. F |
| CHECKED H | APPROVED H | DRAWING NO. D3391 | SHEET 4 OF 5 |
| DATE 07.01.18 | TITLE 412 FLOAT SKIDTUBE | SCALE 1:12 | |



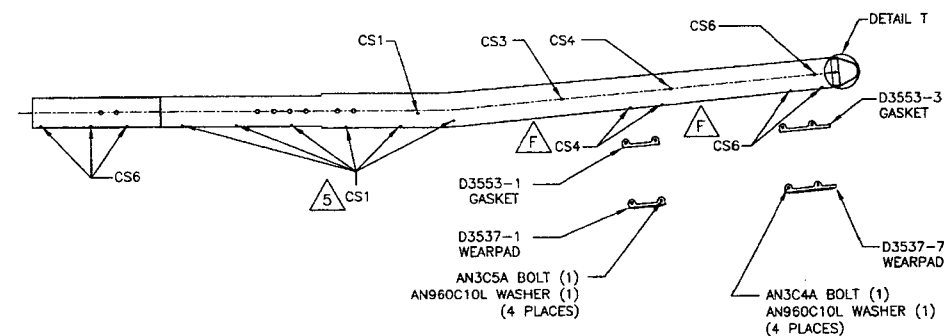
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



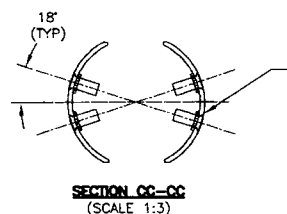
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



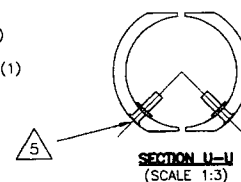
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

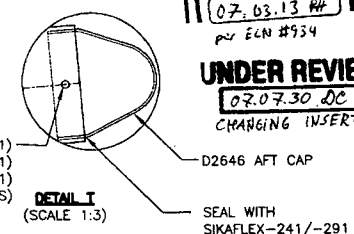
| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | X | D3391-015 | AFT TUBE ASSEMBLY |
| | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 18 | 14 | NAS1330S3KB366 | INSERT (OR AES10KB366) |
| 4 | 2 | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8 | 6 | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4 | | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16 | 12 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4 | | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 2 | 2 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |



DRILL 'O' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N |
|--------------|---------------|---------------|--------|----------------|
| CS1 | 18 | 14 | Ø0.425 | NAS1330S3KB366 |
| CS2 | 4 | | Ø0.391 | NAS1330S3KB366 |
| CS3 | 4 | 2 | Ø0.391 | NAS1330S3KB316 |
| CS4 | 8 | 6 | Ø0.391 | NAS1330S3KB266 |
| CS5 | 4 | | Ø0.391 | NAS1330S3KB216 |
| CS6 | 16 | 12 | Ø0.391 | NAS1330S3KB166 |

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| | | | |
|----------|----------|--------------------------------------|--------------|
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. | REV. F |
| CHECKED | APPROVED | DRAWING NO. D3391 | SHEET 5 OF 5 |
| DATE | TITLE | 412 FLOAT SKIDTUBE | SCALE |
| 07.01.18 | | | 1:12 |

RELEASED
07.03.13 RH
per ECU #534
UNDER REVIEW
07.07.30 DC
CHANGING INSERTS